

Date: Wednesday, 26/11/2008 12:46:07 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: CONSOLE SIDE LH (206 HI-SLOPE)		
Job Number	: 43753			Part Number	: D26022		
Estimate Number	: 11001			Drawing Number	: D2602 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 26/11/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 10/12/2008		
Previous Run	: 42145			Qty:	4	Um:	Each
Written By	:						
Checked & Approved By	: <u>JUL 08.11.26</u>						
Comment	: Est. E 04.02.25 Reformat KJ/RF						
	Note: Issue with part number D2602-1						
	Est Rev:E Now On Waterjet 07-03-22 JLM						
	Est Rev:F RevB as per dwg ECN1059 DD vereified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
	Comment: Qty.: 1.4146 sf(s)/Unit Total : 5.6582 sf(s) 2024-T3 .040 sheet Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <u>107461</u> HB 8-12-10	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D2602 *****Same Cutting File for -1 & -2 ***** Dwg Rev: <u>B</u> HB 8-12-10 Prog Rev: <u>B</u>	 <u>5</u>
	2-Deburr if necessary	HB 8-12-10
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	HB 8-12-10
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	 <u>8 08 12 10 B</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 26/11/2008 12:46:07 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 43753

Part Number: D26022

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Deburr if necessary
2-Form as per Dwg D26022



SS 09/01/05

(S)

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SS 09/01/05 (X)

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Awm 9-1-06



(5)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SS 09/01/07 (5)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST175

SS 09/01/07 (X)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

SS 09/01/07

Job Completion



u 09.01.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

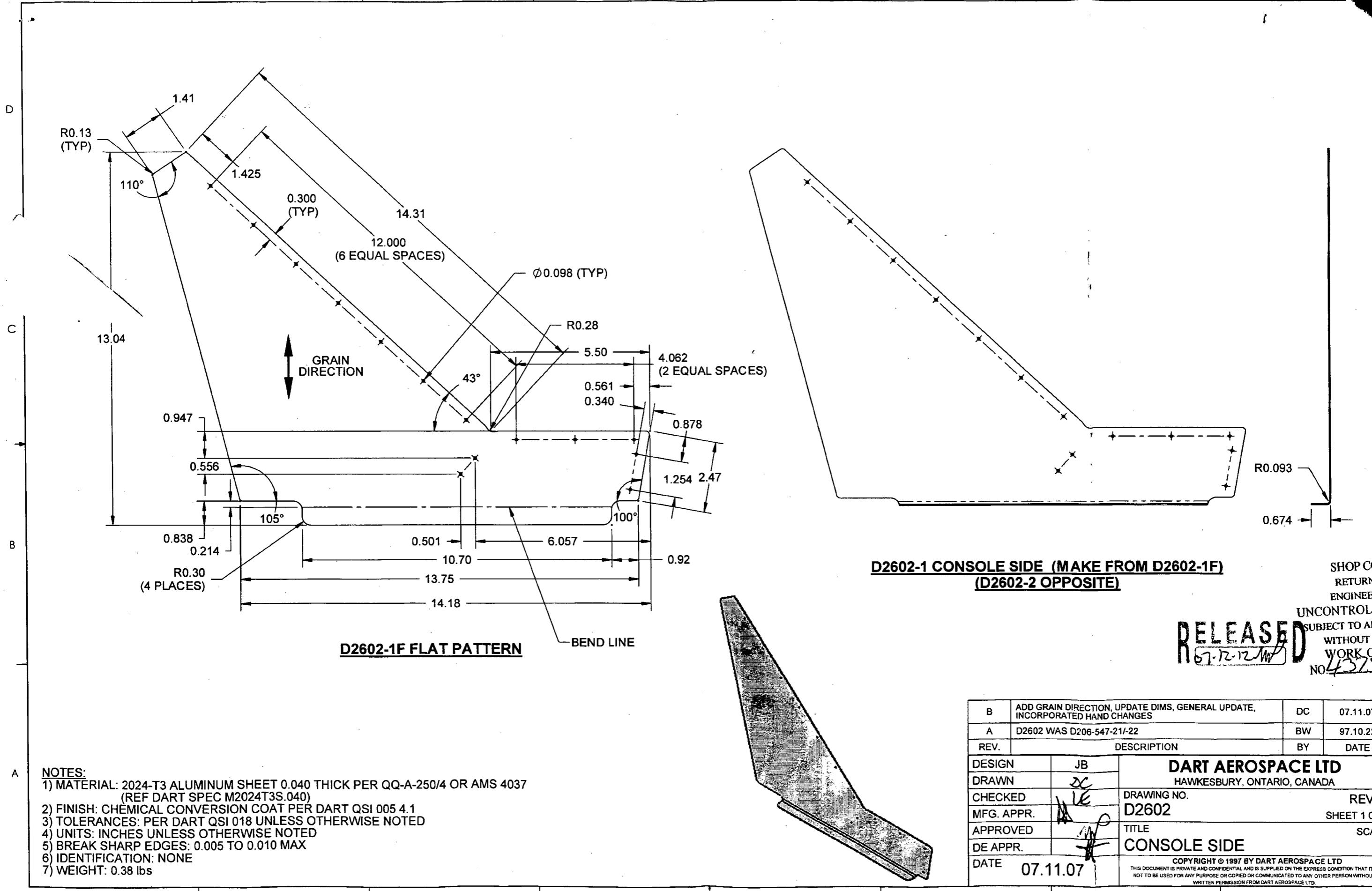
DART AEROSPACE LTD	Work Order:	43753
Description: Console Side LH/RH	Part Number:	D2602-1/1-2
Inspection Dwg: D2602	Rev: A1	B Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>JB</u>	Audited by:	<u>J</u>	Prototype Approval:	N/A
Date:	<u>8-12-10</u>	Date:	<u>06/12/10</u>	Date:	

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	PF



NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4042 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.38 lbs

D2602-1 CONSOLE SIDE (MAKE FROM D2602-1F)
(D2602-2 OPPOSITE)

UNCLASSIFIED
RELEASED SUBJECT TO AMENDMENT
07-12-12 M WITHOUT NOTICE
WORK ORDER
NO: 43753

B	ADD GRAIN DIRECTION, UPDATE DIMS, GENERAL UPDATE, INCORPORATED HAND CHANGES		DC	07.11.07
A	D2602 WAS D206-547-21-22		BW	97.10.22
REV.	DESCRIPTION		BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	DC			
CHECKED	IE	DRAWING NO.	REV. B	
MFG. APPR.	AS	D2602	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		CONSOLE SIDE	1:3	
DATE	07.11.07	COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		